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RBE350A94-3700-A
Job Sheet 197470



Part No: RBE350A94-3700-A

Job Qty: 10 pcs *2 MLC*

Part Name: Swashplate Immobilizing Tools Long Brace & Parts



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/9/19

Job Tracking No:

Due Date: 8/9/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A94-3700-A Rev 7 IPP Rev A 18.01.16 New Issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	10 pcs	8/9/19		0.00	1.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	10 pcs	8/9/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	10 pcs	8/9/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

GP 19-10-04

OCT 07 2019

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7/9/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	10 pcs	8/9/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

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Part Op 110 - (Small Fab) Pick, bag and tag.

Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE350A94-3700-A-1A	Long Brace Assembly	6 - 30 pcs (3 ea)	110-Small Fab - 1	5198962

GA141A

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	RBE350A94-3700-A-1A	30	0	0

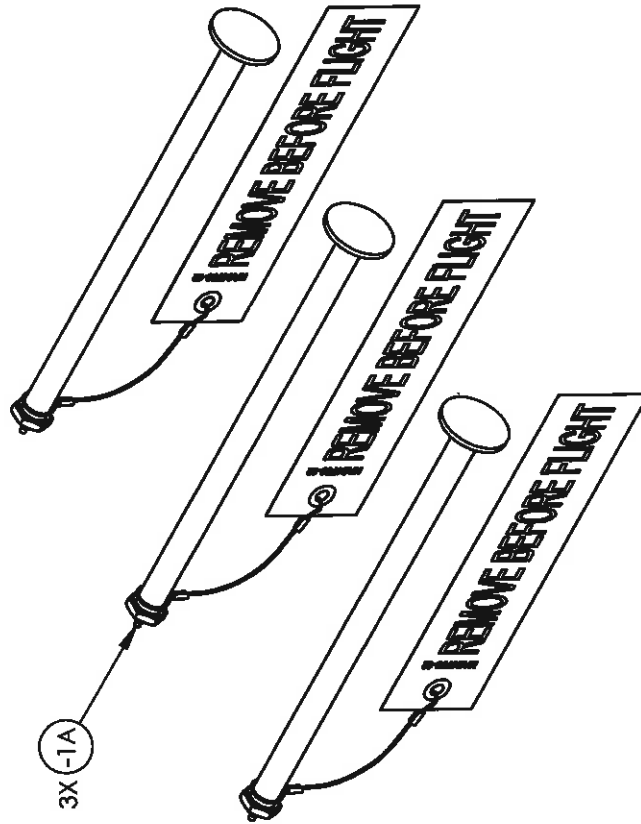
Part Specifications

Specifications could not be found.

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
4		BROKE OUT FROM KIT AS INDIVIDUAL TOOL	8/21/2012	RJC
5		-03 ADDED P.F. -01 TO CAP PIN. -05 ADDED P.F. -01 TO FOOT PIN DIAMETER.	4/17/2013	CFS
5A		CHD T/N WAS RBEA94-3700-A IS RBE350A94-3700-A. DELETED ASSY. FROM TOOL NAME.	10/23/2013	CFS
6	15-0212	-A DELETED ENGRAVE NOTE. CHD DIM WAS 14.60 ± 0.02. -01 CHD OAL WAS 14.173 IS 14.164. ADDED ENGRAVE NOTE.	8/14/2015	RJC
7	14-0282	ADDED USED IN KITS NOTE. -1A ADDED TO BOM QTY: 3. ADDED DRAWING. -01, -03, -05 ADDED FINISH BLACK OXIDE QMSH-422. B.O. REV D. -01 ADDED DIMS Ø.6040-.6047 (P.F. -03), .88, Ø.6040-.6047 (P.F. -05), .88. CHD MATL WAS STEEL IS DOM. -03 CHD DIMS WAS .04 IS 2X .04. WAS P.F. -01 IS Ø.6052-.6056 (P.F. -01). -05 CHD DIM WAS P.F. -01 IS Ø.6052-.6056 (P.F. -01). CHD MATL WAS 1018/1020 IS 1018/1020 CR. -09 QTY: 1. -11 QTY: 2 ADDED TO -1A ASSY.	1/3/2017	DPD



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197470 MLS
1907-09

NOTES:

- CROSS REFERENCE No.'S
RED BARN No.'S + HELIPRODUCTS No.'S
RBE350A94-3700-A-01 = E-350A94-3700-40
RBE350A94-3700-A-03 = E-350A94-3700-22
RBE350A94-3700-A-05 = E-350A94-3700-21
FOR REFERENCE ONLY
- USED IN KITS:
RBE350A94-2700-05
RBEA62309

DART
AEROSPACE

TITLE		PG.		B/O INFORMATION OR SPECIFICATIONS		Material		Description		UNIT QTY		Part #		B/O		ASSY QTY	
SWASHPLATE IMMOBILIZING TOOL LONG BRACE		2								3		-1A		1		X	
RBE350A94-3700-A		3				DOM						-01		1		1	
		4				SP						-03		1		1	
		5				1018/1020 CR						-05		1		1	
		2		M6 X 1 X 30mm (MCMASTER-CARRER #92905A225)		STEEL		EXTENDED POINT SET SCREW, DOG POINT				B/O		1		1	
		2		NAS 1756-12		NYLON		REMOVE BEFORE FLIGHT				B/O		1		1	
		2		Ø11/16 X 14 (CARR LANE #CL-2-C)		COATED STEEL		LANYARD				B/O		1		1	
		2		Ø11/16 X 3/8 (MCMASTER-CARRER #3896131)		ALUMINUM		FERRULE				B/O		2		2	
														ASSY		-1A	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
FRACTIONS 1/8
.XXX ± .006
XX ± .01
X ± .1
ANGLES ± 1°
SURFACES ± .125
1. BREAK ALL SHARP EDGES
.015 X 46° OR .01R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. ASME Y14.5M-2009
USED ON MODEL
EUROCOPTER AS350/355

SCALE 1:5
DATE 8/21/2012
SHEET 1 OF 5



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
☐	☐	☐	☐
Crushing	BOM/Route	Grain Direction	Drawing
☐	☐	☐	☐
Cracks	Broken/Damage/Defect	Weld	Finish
☐	☐	☐	☐
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
☐	☐	☐	☐
Marks/Chatter	Drill Holes	Out of Sequence	Misread
☐	☐	☐	☐
Mislabeled	Fit/Function	Off-set/Set-up	
☐	☐	☐	

Other/Details: _____